



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3996-FE-832-EF
Job Sheet 204574



Part No: D3996-FE-832-EF

Job Qty: 500 pcs

Part Name: Self-Clinching Fastener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/13/19

Job Tracking No:

Due Date: 1/3/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
100	Purchasing 2019 DEC 18 2019 DAS 13 9-89 PO 413045434	500 pcs	1/3/20	0.00 0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	DP	DEC 23 2019
110	Packaging 2-1 - Receive -	500 pcs	1/3/20	0.00 0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B Packaging 2 - 28 - B4B	DP	DEC 23 2019

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S243416

Part: D3996 - FE - 832 - EF

Job No: 204574

Serial No/Batch: S243416

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/23/19

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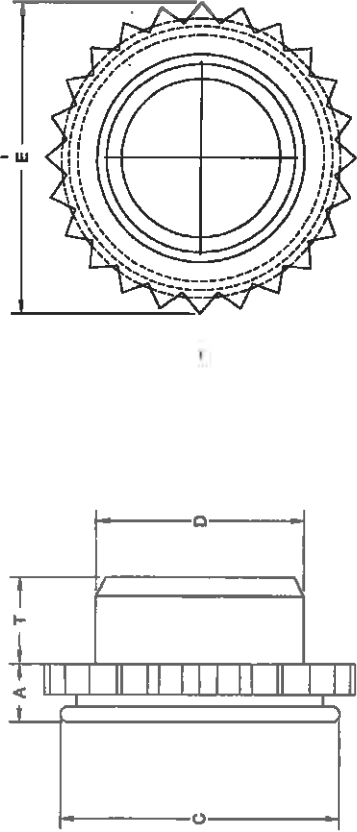
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
120 QC 6	500 pcs	1/3/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	JAN 0 3 2020
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	500 pcs	1/3/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	500 pcs	1/3/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - (Purchasing) Issue P/O: _____ Purchase Part Number: FE-832-EF Supplier: KLX
Descriptions: 110 - (Receive & Inspect for Damage & Mat'l Certs)
120 - (QC6- All purchased or subcontracted products)
130 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
FE-832-EF	Pem Insert D3996-FE-832-EF	500 Ea (1 ea)	100-Purchasing	5243815
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	FE-832-EF	500	51	0
Part Specifications				
Specifications could not be found.				

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SPECIFICATION CONTROL DRAWING



D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C	D MAX	E	T	HOLE SIZE IN SHEET +0.003/-0.000	MIN DIST. HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FE0	0.040	0.039-0.045	0.171	0.145	±0.005	+0.015 -0.000	0.172	0.14	0.00031
#6-32 (0.138)	632	FE	0.060	0.059-0.070	0.212	0.180	0.244	0.075	0.213	0.17	0.00037
#8-32 (0.164)	832	FE0	0.040	0.039-0.045	0.288	0.215	0.322	0.090	0.290	0.20	0.00068
#10-32 (0.190)	032	FE	0.060	0.059-0.070	0.288	0.245	0.322	0.110	0.290	0.20	0.00104
1/4-28	D428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

NOTES
1) SPECIFICATION: PENNINGENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING
PEM PIN XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FE0" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE
"YYY" = THREAD CODE PER TABLE
"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:
DART PIN = D3996-FE-832-EF
PEM PIN = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:
"C" = CADMIUM YELLOW CHROMATE PER ASTM B786 CLASS 5 TYPE II
"CI" = CADMIUM CLEAR CHROMATE PER ASTM B786 CLASS 5, TYPE III
"EF" = ELECTRO FILM PER MIL-STD-883C
"ND" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART, QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

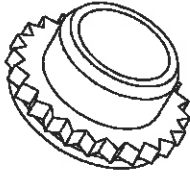
A	NEW ISSUE	DESCRIPTION	CP	BY	DATE
REV.					
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	09.10.01				

REV. A	REV. A
SHEET 1 OF 1	SHEET 1 OF 1
SCALE	SCALE
NTS	NTS

DART AEROSPACE LTD	DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA	HAWKESBURY, ONTARIO, CANADA
DRAWING NO.	DRAWING NO.
D3996	D3996
TITLE	TITLE
SELF-CLINCHING FASTENER	SELF-CLINCHING FASTENER
DATE	DATE
09.10.01	09.10.01

RELEASED
R 2009-11-08
19-12-13

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 204574MCS



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐							
Date :	Sequence #:		QTY Affected :		MRB (QS1042)						
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
								Completed By			
								Lead hand / Supervisor			
								QC / QA Coordinator			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB045434



Supplier: KLX001-VU
Boeing Distribution Services Inc.
10000 Nw 15Th Terrace
Miami, FL 33172 USA
Phone: 425-923-2751
Fax: 305-507-7191

Attention: Pilon, Lucie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045434
PO Date: 12/18/19
Due Date: 12/31/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Fedex Economy
Pymt Terms: Net 30
Freight Terms: Collect
Special Comments:

Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		MS21042L6			Nut	Received		12/31/19	300 Ea	300 Ea	0 Ea	\$0.55/Ea	\$0.00
2		AN6C12A		25/pk	Bolt	Received		12/31/19	100 Ea	100 Ea	0 Ea	\$1.63/Ea	\$0.00
3		NAS1291C8			Nut, Self-Locking	Firmed		12/31/19	25 Ea	0 Ea	25 Ea	\$4.86/Ea	\$121.50
4		NAS1802-4-24			Bolt	Firmed		12/31/19	30 Ea	0 Ea	30 Ea	\$14.80/Ea	\$444.00
5		BLC4RA10S			Pip Pin	Firmed		12/31/19	4 Ea	0 Ea	4 Ea	\$18.21/Ea	\$72.84
6		MS21069-5			Anchor Nuts	Firmed		12/31/19	20 Ea	0 Ea	20 Ea	\$2.12/Ea	\$42.40
7		80-004-2-8			Insert	Firmed		12/31/19	20 Ea	0 Ea	20 Ea	\$3.16/Ea	\$63.20
8		MS20257-3-7200		6ft pcs	Piano Hinge	Received		12/31/19	36 ft	36 ft	0 ft	\$2.70/ft	\$0.00
9		MS21075L5			Nut Plate	Firmed		12/31/19	75 Ea	0 Ea	75 Ea	\$1.46/Ea	\$109.50
10		MS21083C8			Nut	Received		12/31/19	50 Ea	50 Ea	0 Ea	\$3.46/Ea	\$0.00
11		MS24665-136			Cotter Pins	Received		12/31/19	750 Ea	743 Ea	7 Ea	\$0.02/Ea	\$0.14
12		MS27039-1-19			Screw	Firmed		12/31/19	200 Ea	0 Ea	200 Ea	\$0.20/Ea	\$40.00
13	204569	MS28775-011			O-Ring D2594-3 AS PER DWG D2594 REV. C	Received		12/31/19	500 pcs	500 pcs	0 pcs	\$0.15/pcs	\$0.00
14		NAS1611-005			O-Ring	Received		12/31/19	100 Ea	100 Ea	0 Ea	\$0.35/Ea	\$0.00



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PURCHASE ORDER
POHB045434



Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
15	204715	MS28775-008			O-Ring D2651-3 AS PER DWG D2651 REV. B	Received	-	12/31/19	100 Ea	100 Ea	0 Ea	\$0.15/Ea	\$0.00
						X100			DEC 23 2019			DP	
16	204574	FE-832-EF			Pem Insert D3996-FE- 832-EF	Firmed	-	12/31/19	496 Ea	0 Ea	496 Ea	\$0.66/Ea	\$327.36
						X496			DEC 23 2019			DP	639.99

Grand Total: \$1,220.94

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A016 PERSONNEL QUALIFICATION
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A032 DOCUMENT SPECIAL REQUIREMENTS
A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS
A040 NOTIFICATION OF QUALITY ESCAPE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Boeing Distribution Services Inc.

Tel: +1.305.925.2800 Fax: +1.305.507.7191 www.BoeingDistribution.com
Remit to Address: 88289 Expedite Way, Chicago, IL 60695-0001
Wire Instructions: Boeing Distribution Services INC. JPMorgan Chase Bank New York
ABA: 021000021 Account: 304639273 SWIFT: CHASUS33 CHIP UID: 0002

INV:JXYVZ0

PickTkt Number

ELL351.105

Page 1 of 1

Sold To:

002409
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY, K6A 1K7
Canada



Ship To:

DART AEROSPACE LTD
1270 ABERDEEN ST
613-632-9577
HAWKESBURY,ON K6A 1K7
Canada

Order No: POHB045434	Date: 12/20/19	Ship Via: FEDX INTL ECON COLL	Terms: NET 30	Shipping Terms: FCA-SELLER'S WHSE
Item No: 6	Quantity Ordered 500	Part Number and Description: FE-832-EF NUT ECCN : EAR99 Tariff : 7318.16.0085 Schedule B : 7318.16.0000 MFR : PENN ENG & MFG. / ATLAS ENG Ctrl# : 2019C36960 Lot# : 1458340 Lot Qty : 500 Country of Origin: US Cust PN: FE-832-EF Cage Code: 46384 Net weight: 0.567 LB / 0.3 KG CTN: MK000001666415	Unit: EA	Shipped: 500
These items are controlled by the U.S. Government and authorized for export only to the country of ultimate destination for use by the ultimate consignee or end-user(s) herein identified. They may not be resold, transferred, or otherwise disposed of, to any other country or to any person other than the authorized ultimate consignee or end-user(s), either in their original form or after being incorporated into other items, without first obtaining approval from the U.S. government or as otherwise authorized by U.S. law and regulations.				
MATERIAL TO BE RETURNED MUST HAVE PRIOR AUTHORIZATION BY BOEING DISTRIBUTION SERVICES INC.				

ALL ITEMS ARE SUBJECT TO A 100% RESTOCKING CHARGE

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Jason Lewis
Senior Director, Global Quality

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<https://www.boeingdistribution.com/aero/conditions-sale/>

